



Dart Aerospace Ltd.
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D3285-1

Job Sheet 203170



Part No: D3285-1

Job Qty: 20 pcs

Part Name: Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 12/6/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 04.07.14 New issue KJ/JLM IPP Rev:B Now on Waterjet 07-03-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs	12/6/19	12/6/19	0.17	1.34	Waterjet - Flow		JRB 11/20/19
120	QC 8	20 pcs	12/6/19	12/6/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
150	Packaging 3 - 1 - Stock - B4B	20 pcs	12/6/19	12/6/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

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Container No: S233265



Part: D3285-1

Job No: 203170

Serial No/Batch: S233265

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/20/19

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
160	QC 21 - SA	20 pcs	12/6/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 120 - QC8- Inspect parts - second check)
 Descriptions: 150 - (Identify as per dwg & Stock Location: LG004)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	3.0540 sf (.1527 ea)	100-Waterjet - Flow - 1	527404

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.080	3	494	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	6.160inches $\pm$ 0.030	6.190 6.130	6.150	
2	Cap	2.900inches $\pm$ 0.030	2.930 2.870	2.90	
3	Cap	0.098inches $\pm$ 0.005 - 0.000	0.103 0.098	0.101	
4	Cap	0.129inches $\pm$ 0.005 - 0.000	0.134 0.129	0.131	
5	Cap	0.420inches $\pm$ 0.010	0.430 0.410	0.423	
6	Cap	1inches $\pm$ 0	1 1	1	
7	Cap	0.720inches $\pm$ 0.010	0.730 0.710	0.718	
8	Cap	0.200inches $\pm$ 0.010	0.210 0.190	.200	
9	Cap	0.280inches $\pm$ 0.010	0.290 0.270	.280	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____		DISPOSITION						DEPARTMENT / PROCESS															
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐						Skid-tube ☐ Machining ☐ Large Fab ☐				Cross tube ☐ Small Fab ☐ Finishing ☐				Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:		QTY Affected :		MRB (QS1042)																		
Description Work Order Deviation					Disposition																		
					Completed By																		
					Lead hand / Supervisor																		
					QC / QA Coordinator																		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐					FAULT CATEGORY																		
					Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐						